

Work Material	Inconel 718					
Type NO.	Extension Length	(m/min) Cutting Speed	Speed (min ⁻¹)	Feed (mm/min)	(Aa) Cut of depth	(Ap) Cut of width
X-KSR1020	35mm	30	950~1100	140~180	6~8	1~1.2
X-KSR1020	35mm	60	1700~2000	200~300	6~8	0.04~0.07
X-KSR1020	35mm	60	1700~2000	500~600	0.05~0.1	0.05~0.15
X-KSR1020	50mm	30	950~1100	120~170	6~8	0.9~1.1
X-KSR1020	50mm	50	1600~1900	200~300	6~8	0.04~0.07
X-KSR1020	50mm	60	1700~2000	500~600	0.05~0.1	0.05~0.15
X-KSR1020	70mm	30	950~1100	120~160	6~8	0.8~1
X-KSR1020	70mm	50	1600~1900	200~300	6~8	0.04~0.07
X-KSR1020	70mm	60	1700~2000	500~600	0.05~0.1	0.05~0.15
X-KSR1220	35mm	30	900~1000	140~180	8~10	1.2~1.5
X-KSR1220	35mm	50	1300~1700	200~300	8~10	0.04~0.08
X-KSR1220	35mm	60	1500~1800	500~600	0.05~0.1	0.05~0.15
X-KSR1220	55mm	30	900~1000	120~160	8~10	1.1~1.4
X-KSR1220	55mm	50	1300~1700	200~300	8~10	0.04~0.08
X-KSR1220	55mm	60	1500~1800	500~600	0.05~0.1	0.05~0.15
X-KSR1220	80mm	30	900~1000	120~160	8~10	0.8~1
X-KSR1220	80mm	50	1300~1700	200~300	8~10	0.04~0.08
X-KSR1220	80mm	60	1500~1800	500~600	0.05~0.1	0.05~0.15
X-KSR1605	40mm	30	650~850	120~160	12~14	1.5~2
X-KSR1605	40mm	50	1000~1200	160~220	12~14	0.04~0.08
X-KSR1605	40mm	65	1200~1500	450~550	0.05~0.1	0.05~0.2
X-KSR1605	70mm	30	650~850	120~160	12~14	1~1.2
X-KSR1605	70mm	50	1000~1200	160~220	12~14	0.04~0.08
X-KSR1605	70mm	65	1200~1500	450~550	0.05~0.1	0.05~0.2
X-KSR1605	100mm	30	650~850	120~160	12~14	0.8~1
X-KSR1605	100mm	50	1000~1200	160~220	12~14	0.04~0.08
X-KSR1605	100mm	65	1200~1500	450~550	0.05~0.1	0.05~0.2